

1. (Currently Amended) Method for welding preformed tube-rounds comprising the step of acting upon an individual tube round at a plurality of points on its circumference simultaneously by pinching tools that are individually susceptible to power assisted adjustment essentially towards or away from the longitudinal axis of the tube round so as to bring the longitudinal edges of the tube round into contact with each other to effect the initial positioning of the edges to be welded, the initial positioning in the edge region including dipping a dressing tool into the tube round and forming at least one contact plane for at least one of the edges, and gradually withdrawing the dressing tool from the tube round.
2. (Cancelled)
3. (Currently Amended) Method according to Claim 21, further comprising the step of coupling the withdrawal action of the dressing tool with a motion of at least one of the pinching tools.
4. (Cancelled)
5. (Previously Amended) Method according to Claim 1, further including the step of providing a plurality of sets of pinching tools along the length of the tube round.
6. (Previously Amended) Method according to Claim 5, wherein the sets of pinching tools are adjustable in relation to one another in the longitudinal direction of the tube-round.
7. (Previously Amended) Method according to Claim 5, wherein the sets of pinching tools can be coupled to each other.

8. (Cancelled)
9. (Cancelled)
10. (Cancelled)
11. (Cancelled)
12. (Withdrawn) Machine for welding preformed tubes with a diameter to wall thickness ratio equal to or greater than 65, characterized by a modular construction with at least one
  - initial-centring module (3) and at least one
  - centring and welding module (4), (3) in which the modules are arranged on a common carrier unit (6) so as to be exchangeable and adjustable with respect to each other.
13. (Withdrawn) Machine according to Claim 12, characterized in that a lead-in module (2) is provided ahead of the initial-centring module.
14. (Withdrawn) Machine according to Claim 12 characterized in that modules can be coupled to each other and/or in that modules on the carrier unit (6, 6') can be transferred from the working position to a standby position and vice versa.
15. (Withdrawn) Initial-centring module (3) for a machine according to Claim 12 characterized in that it has a mounting (21, 22, 24) for a plurality of pinching tools (14-20) which form a lead-through opening and can be power-driven individually or

in groups essentially towards the centre of the lead-through opening or away from it.

16. (Withdrawn) Initial-centring module according to Claim 15, characterized in that it has a dressing tool (52) which can be power-driven towards the centre or away from it and which has at least one stop face (52').

17. (Withdrawn) Initial-centring module according to Claim 16, characterized in that the drives of at least one pinching tool and of the dressing tool are coupled by a control device.

18. (Withdrawn) Initial-centring module characterized in that it has at least one magnetic tool (60, 61) which is arranged adjacent to the dressing tool (52).

19. (Withdrawn) Initial-centring module characterized in that it has coupling elements for coupling with other modules.

20. (Withdrawn) Centring and welding module (4) with at least one ring of roller-type tools (30-35) which form a lead-through, characterized in that at least one ring element (30, 31; 32-35) susceptible to power-assisted adjustment is provided.

21. (Withdrawn) Centring and welding module according to Claim 20, characterized in that the adjustable ring elements are provided in the form of two rollers (30, 31) located on either side of the welding beam (26) and adjustable so that the shape of the lead-through in the welding zone can be altered.

22. (Withdrawn) Centring and welding module according to Claim 20, characterized in that the adjustable ring elements are provided in the form of two segments of the ring (32, 33; 84, 35) tiltable about centres of rotation located on either side of the longitudinal axis of the welding beam.
23. (Withdrawn) Centring and welding module with at least one ring of roller-type tools which form a lead-through, characterized in that an internal support-rest is arranged inside the lead-through.
24. (New) Method for welding preformed tube-rounds comprising the steps of:  
acting upon an individual tube round at a plurality of points on its circumference simultaneously by pinching tools that are individually susceptible to power assisted adjustment essentially towards or away from the longitudinal axis of the tube round so as to bring the longitudinal edges of the tube round into contact with each other to effect the initial positioning of the edges to be welded; and  
providing at least one magnetic tool in the region of the edges of the tube round.
25. (New) Method according to Claim 24, further including the step of providing a plurality of sets of pinching tools along the length of the tube round.
26. (New) Method according to Claim 25, wherein the sets of pinching tools are adjustable in relation to one another in the longitudinal direction of the tube-round.
27. (New) Method according to Claim 25, wherein the sets of pinching tools can be coupled to each other.